ABSTRACT

A wrench manufacturing process for manufacturing a rotational-tube wrench comprises the steps of forging, annealing, rolling, punching, drawing, polishing, surface grinding, CNC rough cutting, thermal treatment, vibrating, electroplating, CNC fine cutting and assembling. The additional steps of thermal treatment and CNC or MC fine cutting not only enhance the structural toughness of the wrench but also guarantee high degree of roundness for the receptacle space thereof. The CNC or MC fine cutting also provides the inner wall of the receptacle space with fine tool marks so that the confinement strength of a rotational tube without ratchets therein can be significantly enlarged.